



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB T103311-101
Job Sheet 170797



Part No: RB T103311-101

Job Qty: 6 ea

Part Name: Sleeve Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Due Date: 1/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RB T103311-101 Rev1 IPP Rev A 17.11.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		1/11/18	0.00	0.00	Start Up Container		
110	CNC Lathe	6 pcs		1/12/18	0.00	1.50	MORI SL2500Y		
120	QC	6 pcs		1/12/18	0.00	0.00	QC2		
130	QC	6 pcs		1/12/18	0.00	0.00	QC8		
140	QC	6 pcs		1/12/18	0.00	0.00	QC5		
150	Outsource	6 pcs		1/26/18			ATG001-VC Outsource 104		
160	Packaging	6 pcs		1/26/18	0.00	0.00	Packaging2		
170	QC	6 pcs		1/26/18	0.00	0.00	QC6		
180	Packaging	6 pcs		1/26/18	0.00	0.00	Packaging3 GA		
190	QC21-SA	6 Ea		1/26/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per FOLIO FB682 FOLIO REV: _____ DWG REV: _____ 2-Deburr ENGRAVE T/N,
Descriptions: S/N AS PER DWG
150 - Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER
SEAL - Certificate of Conformity is required

P/O: 038962

FEB 07 2018

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13
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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R2.000	6061T6 Round Bar 2.00	.7500 ft (.125 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/19/18 12:58 PM Dart.lajeunesse.marie

.958'

144 3/1

FEB 12 7 10 2018

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Change No: _____
Operation: _____
Revision: _____
Original Serial #: S038822
PART NO: RB T103311-101

Sleeve Tool



S038822



Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

ACTION Rework ☐ Scrap ☐ Use-as-is ☐ Approved ☐	AGAINST DEPARTMENT/PROCESS				
	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐	
	QTY Effective : _____				MRB (QS1042) Approval
	Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval

FAULT CATEGORY		
☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence

Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Crashing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐
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OTHER :

DART AEROSPACE LTD		Work Order:	170797
Description: wear sleeve installation tool-free whirling		Part Number:	
Inspection Dwg:	Rev:		Page 1 of 1

INSPECTION SHEET

Measured by:		Checked by:		QC Inspector:	
Date:	18-02-02	Date:	FEB 06 2018	Date:	

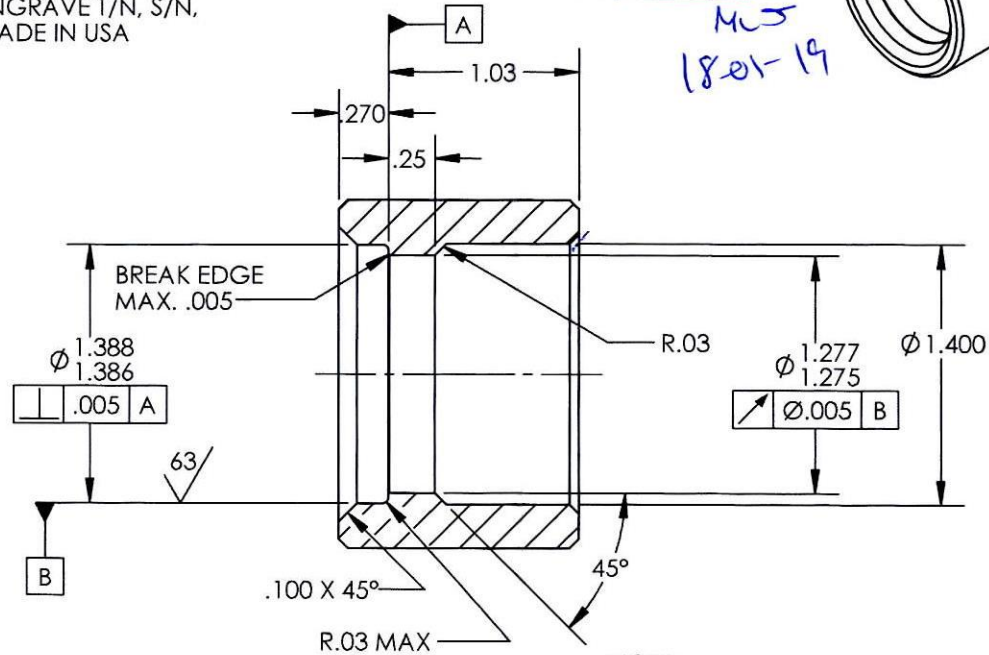
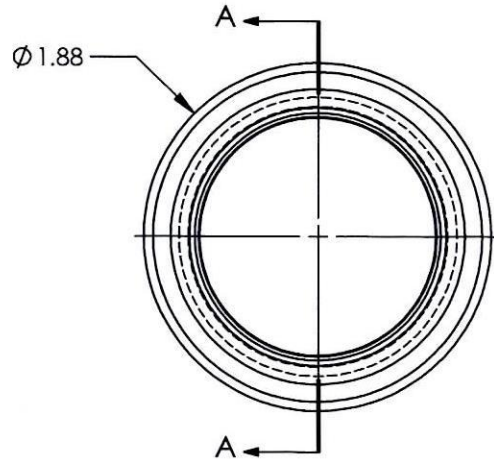
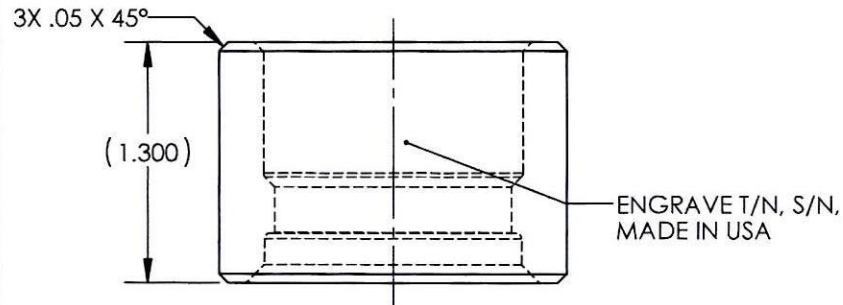
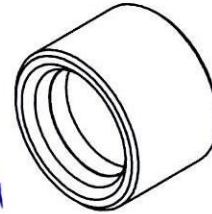
Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
1	15-0077	REDRAWN FROM ORIGINAL TATTERED DWG. CH'D MATERIAL WAS 7075 IS 6061.			4/15/2015	RJC JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170797

MJS
1801-19



SECTION A-A

NOTE:
REF. BELL T/N: T103311 REV A.

DART AEROSPACE	
TITLE WEAR SLEEVE INSTALLATION TOOL-FREE WHEELING	
DWG NO. RB T103311-101	REV 1
MAT'L 6061	DRAWN BY: CLOUGH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 5° .X ± .1	APPROVED <i>J. Gilbert</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	HEAT TREAT FINISH CLEAR ANODIZE
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC MIL-A-8625F, TYPE II, CLASS I USED ON MODEL BELL OH-58D
SCALE 1:1	DATE 4/15/2015 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	SLEEVE	6061		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038962**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038962

PO Date: 2/6/18

Due Date: 2/14/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
FEB 17 2018

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170205	RBW6705G02631-3G-1 ✓	Lever Rigging Fork, T/R Actuator CLEAR ANODIZE (RED BARN) -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant - Certificate of Conformity is required	Firmed	2/16/18	2 pcs 8x	0 pcs 9x	2 pcs AT 18/02/16	\$9.38/pcs	\$18.76
2	170188	RBW6705G02431-3G-1 ✓	Lever Rigging Fork -Issue P/O to ATG: - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	2/16/18	7 pcs ✓	0 pcs 7x	7 pcs AT 17/02/16	\$9.38/pcs	\$65.66
3	170797	RB T103311-101	Sleeve Tool -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required	Firmed	2/16/18	6 pcs ✓	0 pcs 6x	6 pcs AT 18/02/16	\$9.38/pcs	\$56.28
4	170590	RBE350A94-5201-20	Cartridge, Dummy, Fuel -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/16/18	6 pcs ✓	0 pcs 6x	6 pcs AT 18/02/16	\$13.55/pcs	\$81.30

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Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	171148	RBE703A95-0520-01-1	Quill -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	2/16/18	6 pcs	0 pcs	6 pcs	\$13.55/pcs	\$81.30
6	170554	647.0113	Strut Doubler Issue P/O to ATG : Hard anodize, Color Black and Prime as Per Dwg 647.0100 Rev. A	Firmed	2/28/18	16 pcs	0 pcs	16 pcs	\$12.80/pcs	\$204.80
7	170470	646.3715	Strut Doubler Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed	2/28/18	24 pcs	0 pcs	24 pcs	\$7.30/pcs	\$175.20
8	169913	SWA6A-700	Wire Clamp -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	2/28/18	20 pcs	0 pcs	20 pcs	\$5.10/pcs	\$102.00
9	169727	SWA10A-700	Wire Clamp : IPP Rev A 17.11.08 New issue DP Verify DD -Issue P/O to ATG: -HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 -Certificate of Conformity is required	Firmed	2/28/18	12 pcs	0 pcs	12 pcs	\$5.10/pcs	\$61.20
10	170474	646.3719	Doubler Issue P/O _____ ATG, balck anodize and prime as per dwg 646.3719 Rev. A	Firmed	2/28/18	24 pcs	0 pcs	24 pcs	\$7.30/pcs	\$175.20
11	168246	646.3716	Gauge Bracket Issue P/O to ATG : _____ ATG, balck anodize and prime as per dwg 646.3716 Rev. A	Firmed	2/28/18	10 pcs	0 pcs	10 pcs	\$7.20/pcs	\$72.00
12	170472	646.3717	Doubler Issue P/O _____ ATG, black anodize and prime as per dwg 646.3717 Rev. A	Firmed	2/28/18	12 pcs	0 pcs	12 pcs	\$7.30/pcs	\$87.60
13	170473	646.3718	Custom Washer Issue P/O _____ ATG, black anodize and prime as per dwg 646.3718 Rev. A	Firmed	2/28/18	30 pcs	0 pcs	30 pcs	\$5.00/pcs	\$150.00
Grand Total:									\$1,331.30	

Order Notes





A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914638

Date: 16-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: RBW6705G02631-3G-1 Lever Rigging Fork, T/R Actuat Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22501		Rev: 1A PO: PO038962 Line: 1
7 ea	Part: RBW6705G02431-3G-1 Lever Rigging Fork M/R Actuator Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22503		Rev: 1B PO: PO038962 Line: 2
6 ea	Part: RBT103311-101 Sleeve Tool Anodize per MIL-A-8625F, Type II, Class 1, Clear, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22504		Rev: 1 PO: PO038962 Line: 3
6 ea	Part: RBE350A94-5201-20 Cartridge, Dummy, Fuel Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22505		Rev: 1A PO: PO038962 Line: 4
6 ea	Part: RBE703A95-0520-01-1 Quill Anodize per MIL-A-8625F, Type II, Class 2, Red, .0004-.0010" (.4 - 1 mils), Water Sealant Job: 22506		Rev: 4 PO: PO038962 Line: 5
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements.			
Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914638

Date: 16-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms

Ship Via

OUR TRUCK

Quantity

Description

Date:

Certified Signature:

Receiver Signature:

A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.

Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.

Made in Canada.